

Work Order ID 93539

Monday, November 19, 2012 4:22:18 PM

Item ID: D412-711-101

Accept

93539

Page 1

Revision ID:

Item Name: Replacement Bubble Window

Start Date: 11/19/2012 Start Qty: 200

2

Required Date: 11/23/2012 Req'd Qty: 2.00

2

Reference:

Approvals: Process Plan: *MLF*

Date: 12-11-19

QC:

Date:

Tooling:

SPC (Y/N):

Cust Item ID:

Customer:

Setup Start ***NS1***Stop ***NS2***Sequence ID/
Work Center IDOperation
Description

Draw Nbr

Revision Nbr

D412-711-101

A

100

100

DC

Document Control

Memo

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

110

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

0.00

0.00

0.00

0.00

120

120

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

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Work Order ID 93539

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Page 2

Item ID: D412-711-101**Accept*****N900040100*****Setup****Start*****NS1*****Revision ID:****Item Name:** Replacement Bubble Window**Stop*****NS2*****Start Date:** 11/19/2012 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 11/23/2012 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run****Start*****NR1*****QC:****Date:****SPC (Y/N):****Date:****Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

130

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

0.00

X1

B 12/11/20

Memo 0.00

Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA

077

Dwg. Rev. AFolio Rev. X

Visually inspect for proper formation and clarity

160

160

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

0.00

Memo 0.001) Trim off excess flange material
2) Buff out any light scratches or
3) Etch part number and batch number

B 12/11/22

170

170

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo 0.00

1) Visually inspect for clarity, and proper formation.

B 12/11/22

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Item ID: D412-711-101

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Bubble Window

Stop

NS2

Start Date: 11/19/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/23/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
Description

180

180

QC

Quality Control

185

185

QC

Quality Control

190

190

Packaging

Packaging

Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

DAS
16
8-89

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

12/12/23

X

0.00

S
16
8-89
12/12/27

)

0.00

12/12/27

QD

12/11/27 DAS
20
8-89

0.00

D20

Work Order ID 93539

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Page 4

Item ID: D412-711-101

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Bubble Window

Stop

NS2

Start Date: 11/19/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/23/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
Description

200

QC21- Final Inspection - Work Order Release

200

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo

0.00

12/11/28

MF

11-28

12

Picklist Print

Monday, November 19, 2012 4:22:17 PM

Page 1

Work Order ID: 93539

Parent Item: D412-711-101

Start Date: 11/19/2012

Required Date: 11/23/2012

Parent Item Name: Replacement Bubble Window

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
10/06/28 DL

IPP Rev. B. Manufacture in-house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236 Plexiglass G .236"		Purchased	No				sf	325.2755		42.666667			(DAS 07 12-89)

Location	Loc Qty	Loc Code
therm	325.2754524	
119347	0.803174	
120972	0.00227844	
122537	132.47	
122582	192	

21.33 sq ft.

02/11/23

DART AEROSPACE LTD		Work Order:	93539
Description: Replacement Window		Part Number:	D412-711-101
Inspection Dwg: D412-711-101	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *BB*

Date: 12/11/22

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	2.16	✓		DL-01	
1.73	+/-0.030	1.87	✓		DL-01	
1.98	+/-0.030	2.04	✓		DL-01	
1.50	Min	1.51	✓		DL-01	
0.090	Min	.098	✓		ULTRASonic	
0.070	Min	.092	✓		"	
0.050	Min	.082	✓		"	
15.0	+/-0.5	15.06	✓		TH-05	

Measured by: *BB*

Date: 12/11/22

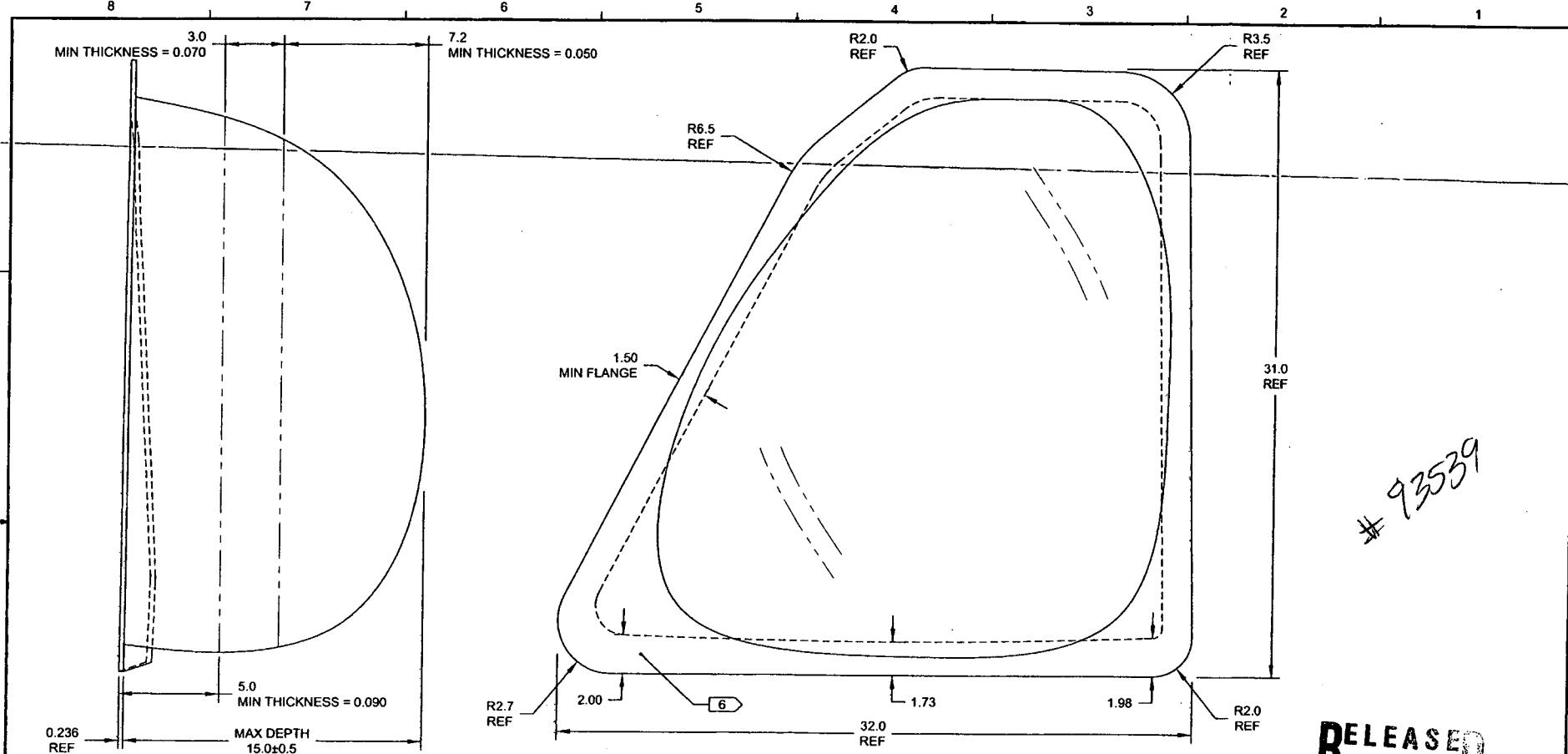
Audited by: *DAS*

Date: *12/11/23*

Preliminary Approval:

Date: *9-6-08*

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ <i>BB</i>	<i>BB</i>



D412-711-101 REPLACEMENT WINDOW

NOTES:

- 1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425, 0.236 THICK (STOCK, REF. DART SPEC. M-ACRYLIC-S.236)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D412-711-101" & B/N "BXXXXX" ON THE INSIDE SURFACE OF THE BUBBLE WINDOW FLANGE, WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX. DEPTH OF 0.005"
- 7) WEIGHT: 8.0 lbs
- 8) VACUUM FORMING: PER FOLIO FTA077 USING DT9640 MOLD AND DART QSI 022

A	NEW ISSUE	MB	10.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.28	SCALE	10.06.28

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D412-711-101 SHEET 1 OF 1

TITLE
REPLACEMENT WINDOW

SCALE
NTS

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